



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15421	3450
2	Machined By		V. T. L. H/c Shop	Dy. No. 122450
3	Pallet Die No.		15474(3.0)H	Rev. 02
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	730H	Step 00. 744H
6	Inside Diameter	Drg. No.	630.14H	748.6
7	Width of Pellet Die	Drg. No.	290.6H	Step length 83.3
8	Grooves as per Drawing	Drg. No.	15.3x8x5H	Under cut 6.9H
9	Fitting Sizes on CNC Plate	Drg. No.	15.3x8x5H	Face Side
10	Drilling Area Surface Smoothness		OK	0.8H
11	Tapping Operator		H/c Shop	Back Side
12	Tapping PCD		685H	Tapping H/c
13	Tapping Hole Diameter		H20	of H. 10.10
14	Tapping On Second Side	Half pitch of 1st side	OK	Back Side
15	Tapping Hole Depth		Drill Depth 20.4H	Tapping Depth 18.9
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/7/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No - 2 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter 6
2	External Relief Dia	3.5H	Outside (3.3)		Inner			Rev. 52
3	External Relief Depth		23H		20H			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Ravi 19/7/25

Manager-QA

Reviewed by (Engineer-CNC)